

Date: * Thursday, 4/12/2007 8:44:56 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 31717		
Estimate Number	: 10533		
P.O. Number	: <u>N/A</u>	Part Number	: D2573
This Issue	: 4/12/2007	Drawing Number	: D2573 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u>	Drawing Revision	: E
Previous Run	: 30594	Material	: <u>N/A</u>
Written By	: _____	Due Date	: 4/30/2007
Checked & Approved By	: <u>9/07.04.12</u>	Qty:	12 Um: Each
Comment	: Est: I As Per RevE 06-01-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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*Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2573
Ensure that grain is along 7.75" length
Batch No: B25354 (x12) En 07/05/03

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. B31717 Double check by: SG

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

MS/SG 01/05/08 12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

MS/SG 01/05/08 12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS/SG 01/05/08 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:44:56 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 31717

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/05/08

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL

07/05/09 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

07/05/09

(12X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/05/10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/10 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/11 (12)

Job Completion



11 JUL 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31717
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.750	1.749		
C	3.495	3.505		3.499	3.500	3.499	3.499		
D	1.745	1.755		1.749	1.748	1.750	1.749		
E	7.990	8.010		8.000	8.003	8.003	8.004		
F	0.490	0.510		0.497	0.496	0.499	0.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.502	0.503	0.502		
J	1.174	1.184		1.177	1.176	1.179	1.179		
K	0.558	0.578		0.562	0.566	0.565	0.565		
L	1.174	1.184		1.177	1.176	1.179	1.179		
M	1.365	1.375		1.367	1.368	1.366	1.366		
N	2.495	2.505		2.498	2.498	2.497	2.498		
O	4.119	4.129		4.121	4.124	4.121	4.121		
P	0.115	0.135		0.128	0.127	0.128	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.252	0.253	0.252		
S	0.115	0.135		0.129	0.126	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.242	0.242	0.239		
W	0.115	0.135		0.132	0.135	0.131	0.129		
X	0.308	0.313		0.310	0.310	0.310	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.520	0.520	0.520		
AB	0.615	0.635		0.628	0.629	0.627	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.250	0.249	0.250		
AE	1.500	1.520		1.512	1.512	1.513	1.513		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.257	0.249	0.248		
AI	2.000	2.020		2.002	2.002	2.003	2.002		
AJ	0.023	0.043		0.033	0.037	0.033	0.033		
Accept/Reject									

Measured by:	En
Date:	07/05/05

Audited by:	SA
Date:	07.05.06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31717
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

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B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.499	3.500	3.500	3.497		
D	1.745	1.755		1.748	1.748	1.748	1.748		
E	7.990	8.010		8.002	8.003	8.004	8.001		
F	0.490	0.510		0.501	0.503	0.498	0.497		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.503	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.175	1.177		
K	0.558	0.578		0.566	0.566	0.565	0.567		
L	1.174	1.184		1.179	1.179	1.175	1.177		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.497	2.497	2.499		
O	4.119	4.129		4.122	4.121	4.121	4.123		
P	0.115	0.135		0.126	0.127	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.257	0.252	0.252		
S	0.115	0.135		0.127	0.127	0.130	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.238	0.240	0.240		
W	0.115	0.135		0.129	0.129	0.133	0.131		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.624	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.246	0.247	0.249		
AE	1.500	1.520		1.512	1.512	1.512	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.257	0.250	0.249		
AI	2.000	2.020		2.001	2.001	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	SD
Date:	07/05/06

Audited by:	SD
Date:	07/05/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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DART AEROSPACE LTD	Work Order:	31717
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

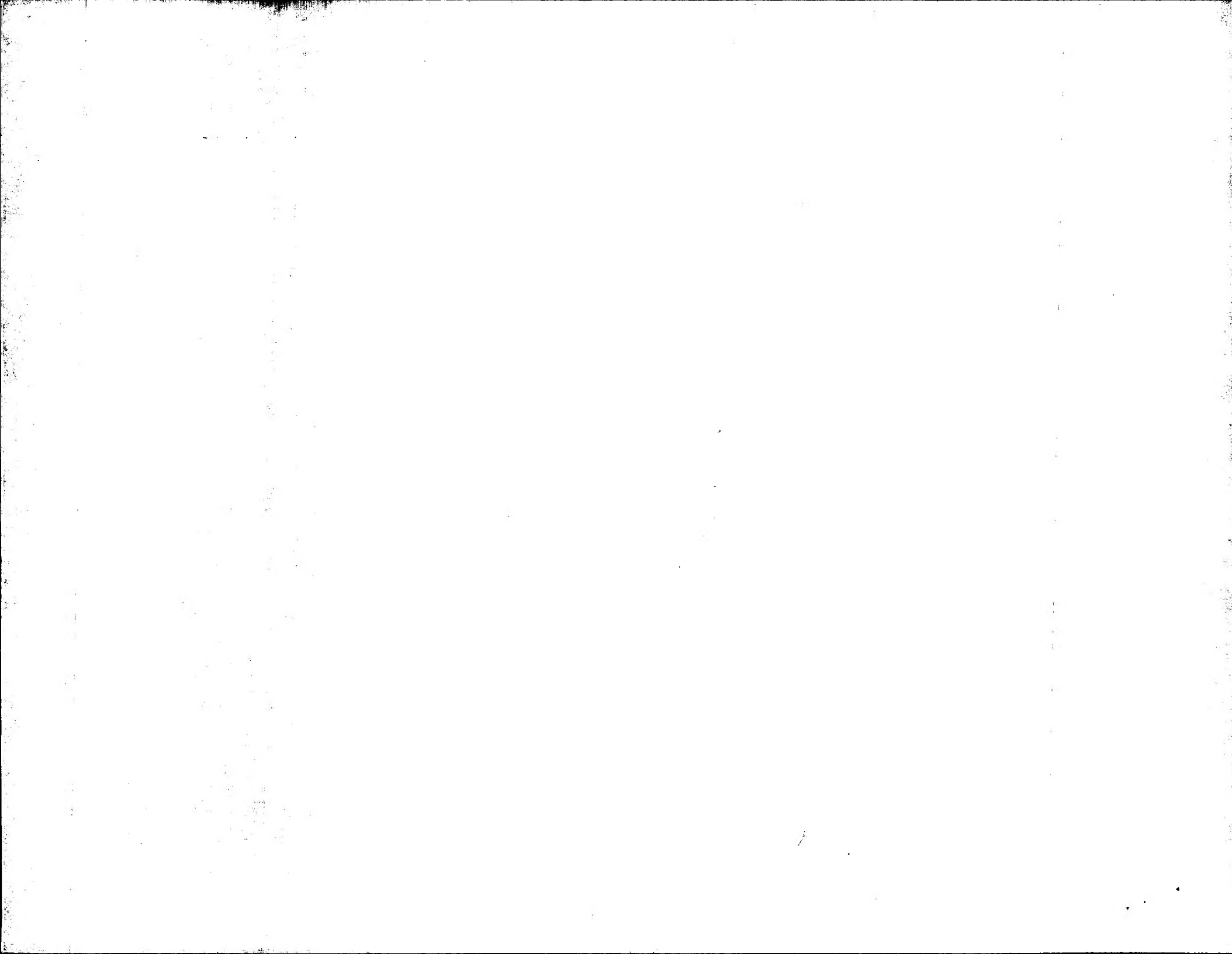
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

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B	1.745	1.755		1.748	1.749	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.749	1.748	1.748		
E	7.990	8.010		8.003	8.001	8.001	8.001		
F	0.490	0.510		0.501	0.502	0.500	0.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.501	0.500	0.500		
J	1.174	1.184		1.178	1.175	1.179	1.179		
K	0.558	0.578		0.566	0.566	0.565	0.565		
L	1.174	1.184		1.178	1.175	1.178	1.178		
M	1.365	1.375		1.366	1.367	1.367	1.367		
N	2.495	2.505		2.497	2.497	2.500	2.500		
O	4.119	4.129		4.121	4.121	4.122	4.122		
P	0.115	0.135		0.126	0.128	0.128	0.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	0.252	0.252		
S	0.115	0.135		0.123	0.127	0.125	0.125		
T	0.178	0.198		0.189	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.237	0.238	0.238		
W	0.115	0.135		0.132	0.132	0.132	0.132		
X	0.308	0.313		0.310	0.310	0.312	0.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.365	0.368	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.628	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.248	0.248		
AE	1.500	1.520		1.512	1.513	1.511	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.251	0.251	0.251		
AI	2.000	2.020		2.002	2.003	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EP / ML
Date:	07/05/08

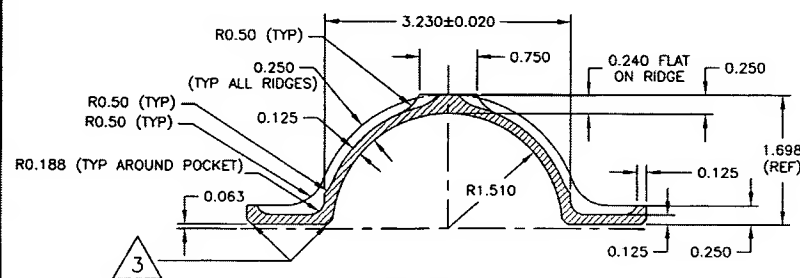
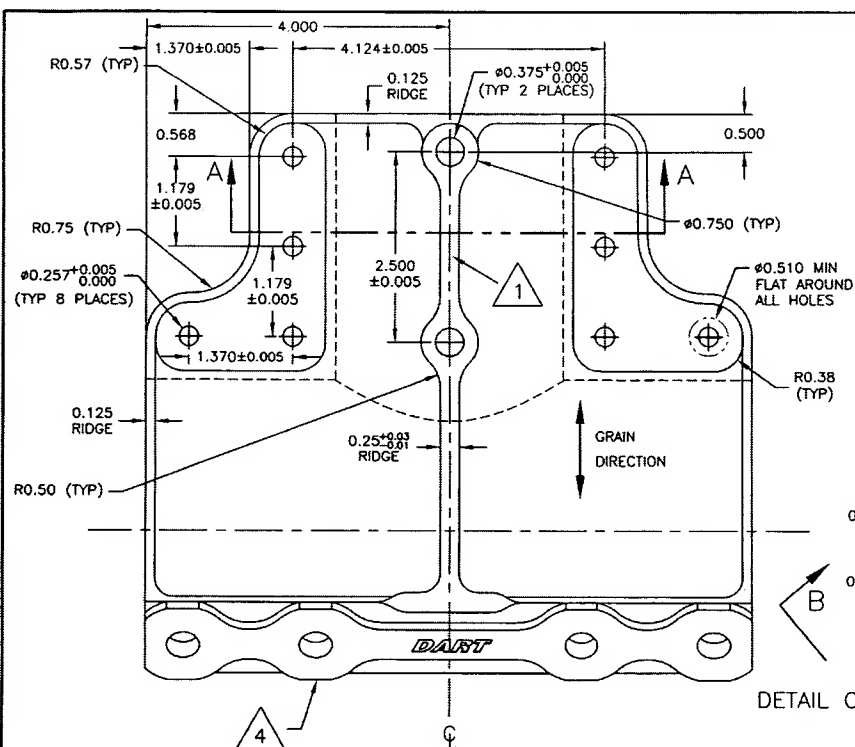
Audited by:	J.L
Date:	07/05/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

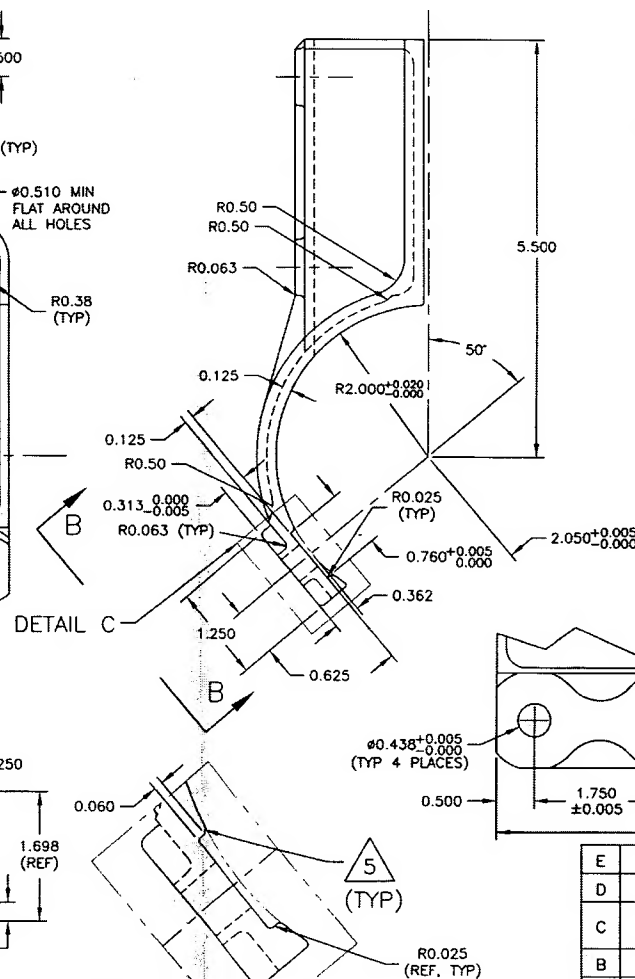


RELEASED

05.12.06 #



SECTION A-A

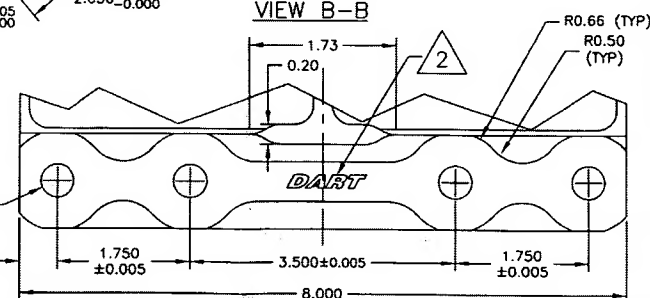
DETAIL C
SCALE 4:3

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4 CHAMFER 0.063" x 45° ALL AROUND
5 CHAMFER 0.033" x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2573
		TITLE OUTER AFT SADDLE
		SCALE 2:3

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DART

DART AEROSPACE LTD.
MARKHAM, ONTARIO, CANADA

REV. E

SHEET 1 OF 1

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WITHOUT NOTICE
WORK ORDER
NO. 31717

